

TECHNICAL DATA SHEET

SF-150 is an epoxy surface film providing excellent surface finish and requiring minimum preparation for painting. It is suitable for processing by autoclave curing. This surface film offers a versatile curing range from 80°C to 140°C.

SHELF LIFE



OUT LIFE ¹
> 4 weeks @ 21 °C



STORAGE LIFE
12 months @ -18 °C

FEATURES



MEDIUM TACK



COLOUR: GREY



MAXIMUM TG (DSC): 150°C



ENVIROMENTAL TEST PV1200 20 CYCLES:
PASS

LAYUP

The film side where the majority of the resin is closest to the surface should be placed against the tool during layup.

MATRIX PROPERTIES

Density @ RT: (average value) 1.60 g/cm³.

Gel time (Hot Plate) @ 140°C : 2 minutes.

AVAILABILITY

240 gsm SF-150 HM surface film, 17 gsm veil carrier;
width 1270 mm.

300 gsm SF-150 HM surface film, 17 gsm veil carrier;
width 1270 mm.

¹ Out life is the maximum time allowed before cure after a single frozen storage cycle in the original prepreg bag unopened stored at -18°C or below for a period not exceeding the above mentioned frozen storage life.

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CURING CONDITIONS

Option 1 - Autoclave Cure ^{1,2}			
Time (min)	Temp. (°C)	Time (min)	Pressure (bar)
0	30	0	1
30	90	10	2
55	90	30	4
75	130	50	6
165	130	165	6
181	50	166	1

Option 2 - Autoclave Cure ^{1,2}			
Time (min)	Temp. (°C)	Time (min)	Pressure (bar)
0	30	0	1
25	80	25	4
300	80	50	6
505	80	505	6
511	50	506	1

PRECAUTIONS FOR USE

The usual precautions when handling uncured resins and fibrous materials should be observed, and a Safety Data Sheet is available for this product.

SDS Reference Codes: SF-150: SDS-422

STORAGE CONDITIONS

This prepreg should be stored as received in a cool dry place or in a refrigerator.

After removal from refrigerated storage, prepreg should be allowed to reach room temperature before opening the polyethylene bag, thus preventing condensation (a full roll in its packaging can take more than 1 day).

¹ Temperature must be measured by the lagging thermocouple attached to the part.

² Vacuum bag pressure: 0.9 bar.